

6/19/2018

SMALL FAB

[Dart Hawkesbury] Job Sheet - David, Logan



Dart Aerospace Ltd.
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RBE350A93-3302-02
Job Sheet 179407



Part No: RBE350A93-3302-02

Job Qty: 2 ea

Part Name: Tail Rotor Hub Lock Wrench



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 8/6/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A93-3302-02 REV:11 IPP REV A 18.01.30 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	8/6/18	8/6/18	0.00	0.00	Start Up Small Fab-4		ML
100	Small Fab	5 pcs	8/6/18	8/6/18	0.08	0.33	Small Fab-9		ML DAS
110	QC	5 pcs	8/6/18	8/6/18	0.00	0.00	QC5		38
130	Packaging	5 pcs	8/6/18	8/6/18	0.00	0.00	Packaging3-2		9-89
140	QC21-FG	5 Ea	8/6/18	8/6/18	0.00	0.00	QC21		SEP 1 2 2018

Part Op 100 - Assemble
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	20 Ea (4 ea)	90-Start up Operation	5095315
90174A113	Retaining Pin	10 Ea (2 ea)	90-Start up Operation	5050272
90177A218	Split Ring	20 Ea (4 ea)	90-Start up Operation	5084070
90272A189	Machine Screw	25 Ea (1 ea)	90-Start up Operation	5039348
94975A162	Quick Release Pin	25 Ea (1 ea)	90-Start up Operation	5054072
CL-2-C	Lanyard Wire	8.3300 ft (1.666 ea)	90-Start up Operation	5026872
RBE350A93-3302-02-1	Handle	25 Ea (1 ea)	90-Start up Operation	5074552
RBE350A93-3302-02-3	Pin	10 Ea (2 ea)	90-Start up Operation	5101665
RBE350A93-3302-02-5	Extension Handle	1 Ea (1 ea)	90-Start up Operation	5094971

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	20	498	0
	90174A113	10	63	0
	90177A218	20	66	0
	90272A189	5	194	0
	94975A162	5	18	0
	CL-2-C	8	319	0
	RBE350A93-3302-02-1	5	12	0
	RBE350A93-3302-02-3	10	12	0
	RBE350A93-3302-02-5	5	0	0

Part Specifications

Specifications could not be found.

Plex 6/19/18 7:46 AM dart.logan.david



Container No: S108916



Part: RBE350A93-3302-02

Job No: 179407

Serial No/Batch: S108916

Revision: 11

Inspector:

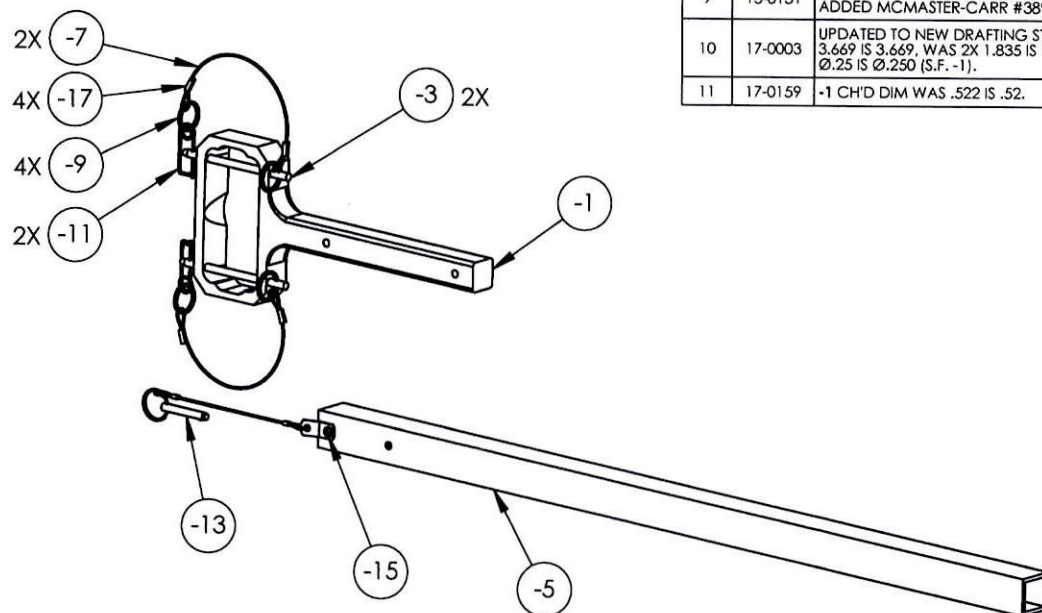
Exp Date:

Instructions:

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Date: 09/10/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D INSIDE ANGLED RADIUS FROM R.75 TO R.375, CH'D DIM WAS 1.122 IS 1.	12/5/2008	WP	DW
2		-1 ADDED Ø.250 HOLE. -5 ADDED #8-32 HOLE & Ø.250 HOLE.	3/18/2009	WP	DW
3		-1 ADDED 1 INCH SQUARE DIM, CH'D DIM TO 2.309. -5 CH'D OD & ID DIMS.	4/29/09	RJC	
4		-5 DELETED ENGRAVE NOTE.	6/1/2009	RJC	
5		-1 ADDED TOLERANCE 1.00 - .98 TO HANDLE. -3 SHORTENED PIN BY 3/8 ON BOTH ENDS. -5 EXTENDED FROM 16.1 TO 30.0, MOVED PIN HOLE FROM 1.25 TO 3.00, CH'D MATERIAL WAS STEEL IS ALUMINUM.	10/6/2009	WP	DW
6		-1 CH'D TOOLING HOLE WAS Ø.266 IS Ø.250, ADDED ENGRAVE NOTE. -5 ADDED ENGRAVE, CH'D TOOLING HOLE WAS Ø.266 IS Ø.250.	12/16/2010	RJC	RW
6A		-5 CH'D TUBE WALL THICKNESS WAS .105 IS .125.	5/10/2012	RJC	GEB2
7		-1 CH'D DIM WAS Ø.250 IS Ø.250 +.005 -.000.	4/18/2013	CFS	JG
8A		CORRECTED T/N WSS RBEA93-3302-02 IS RBE350A93-3302-02.	11/5/2013	RJC	RW
9	15-0131	-7 CH'D WAS MCMASTER-CARR #30345T1 5 IS CARR LANE #CL-2-C. -9 CH'D QTY. WAS 2 IS 4. -17 ADDED MCMASTER-CARR #3896T31.	6/12/2015	RJC	JAG
10	17-0003	UPDATED TO NEW DRAFTING STANDARD. -1 CH'D DIM WAS 3.071 IS 3.07, WAS 5.315 IS 5.32, WAS 2X 3.669 IS 3.669, WAS 2X 1.835 IS 1.835, WAS 4X .190 IS 2X .190. ADDED DIM .522. -3 CH'D DIM WAS Ø.25 IS Ø.250 (S.F. -1).	2/28/2017	RJC	SM
11	17-0159	-1 CH'D DIM WAS .522 IS .52.	6/21/2017	RJC	JAG

NOTE:
ORIGINAL No. REF: RBEA93-3302-2 = 350A93-3302-02.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	HANDLE	6061		2
			-3	2	PIN	S.S.		3
			-5	1	EXTENSION HANDLE	ALUMINUM SQ. TUBE		4
		B/O	-7	2	LANYARD	COATED STEEL	Ø1/16 X 8 7X7 CABLE (CARR LANE #CL-2-C)	1
		B/O	-9	4	SPLIT RING	STEEL	Ø1 O.D. X 1/8 (MCMASTER-CARR #90177A218)	1
		B/O	-11	2	WIRE LOCKING PIN	STEEL	Ø1/16 X 1-1/16 USABLE (MCMASTER-CARR #90174A113)	1
		B/O	-13	1	QUICK RELEASE PIN W/LANYARD	S.S.	Ø1/4 X 1.3 USABLE (MCMASTER-CARR #94975A162)	1
		B/O	-15	1	MACHINE SCREW	STEEL	#8-32 UNC-2A (MCMASTER-CARR #90272A189)	1
		B/O	-17	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1

DART AEROSPACE	
TITLE T/R HUB LOCK WRENCH	
DWG NO. RBE350A93-3302-02	REV 11
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL EUROCOPTER 350/355
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
SCALE 1:6	DATE 10/20/2008 SHEET 1 OF 4